

Work Order ID 73361



Page 1

Wednesday, August 31, 2011 11:39:01 AM

Item ID: D3913-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Base Assembly, 350

Start Date: 8/31/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/12/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: CLDate: 11/08/31

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3913

A

D4020

A

100

Weld per dwg A/R S.S. rod Batch: 117884 0.00

Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble ribs, weld as per dwg D3913 using DT9610A
inspect before welding mesh
2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913
and trim mesh to fit if necessary and trim to clear fasteners holes on the ends
3- weld hinge (3) and Mounting brackets as per dwg D3913
take lid to locate hinge and bracket

11.09.21 (X1)

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

11.09.21 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Required Date: 9/12/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

125

Pressure Wash per QS1005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

IX Ø M-11/04/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Wednesday, August 31, 2011 11:39:01 AM

Page 3



Accept

**Setup Start**

Stop

[illegible]**Cust Item ID:**

b6
b7C

Customer:

Reference:

Run Start



Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00



Memo

0.00

1- Plug holes and mask only interior of hinge (3) prior to powder coat

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*****2nd coat if necessary*****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00



Memo

0.00

Quality Control

IX of m-f 11/04/22

W 118439

1 of 11 11/09/22

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Start Date: 8/31/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 9/12/2011 Req'd Qty: 1.00

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  HandFinish	✓ Assemble as per dwg	0.00				1	0	11/10/22	
Hand Finishing	✓ Memo Pick Kit	0.00							
160  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
170  Packaging	Identify as per dwg & Stock Location: <u>w/o</u>	0.00							
Packaging	Memo	0.00							

D4036-041 / B73357 1 0 11/10/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/23

mf

11-09-23

W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, August 31, 2011 11:38:58 AM

Page 1

Work Order ID: 73361

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350



Start Date: 8/31/2011

Required Date: 9/12/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2581

Manufactured No

100

Each

19.0000

2



Mounting Bracket

Location

Loc Qty

Loc Code

WA

19

69258

14

69739

2

70766

3

2

D3913-1

Manufactured No

100

Each

5.0000

1



Rib

Location

Loc Qty

Loc Code

WA

5

59089

1

69260

2

70346

1

72086

1

1

D3913-15

Manufactured No

100

Each

7.0000

1



Wide Handle Plate

Location

Loc Qty

Loc Code

WA

3

69647

3

WA005

4

69012

1

72550

3

1

1

W/O:		WORK ORDER CHANGES					
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Page 2

Work Order ID: 73361

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 8/31/2011

Required Date: 9/12/2011

Start Qty: 1.00

Required Qty: 1.00

D3913-3

Manufactured No

100

Each

5.0000

1

1



Rib



Pl 11.09.19

Location

Loc Qty

Loc Code

WA

4

69160

1

72664

3

WA006

1

69646

1

D3913-7

Manufactured No

100

Each

12.0000

2

2



Rib



Pl 11.09.19

Location

Loc Qty

Loc Code

WA

4

69521

2

70334

2

WA006

8

65278

1

66435

1

72457

6

D3913-9

Manufactured No

100

Each

5.0000

1

1



Hinge Rib



Pl 11.09.19

Location

Loc Qty

Loc Code

WA

3

72665

3

WA006

2

70138

1

71479

1

Wednesday, August 31, 2011 11:38:58 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Wednesday, August 31, 2011 11:38:58 AM

Page 3

Work Order ID: 73361

Parent Item: D3913-041



Parent Item Name: Long Basket Base Assembly, 350

Start Date: 8/31/2011

Required Date: 9/12/2011



Start Qty: 1.00

Required Qty: 1.00

D3916-041 Manufactured No 100 Each 6.0000 2 2
  PL 11-09-19
 Rib Assembly



Location Loc Qty Loc Code

WA 6
 69161 2
 72543 4

D3916-5 Manufactured No 100 Each 13.0000 3 3
  PL 11-09-19
 Light Rib

Location Loc Qty Loc Code

WA 4
 59088 3
 71938 1
 WA006 9
 72557 9

D4016-1 Manufactured No 100 Each 31.0000 3 3
  PL 11-09-19
 Hinge Half, Base

Location Loc Qty Loc Code

WA 31
 66418 0
 68426 3
 72009 10
 72757 18

Wednesday, August 31, 2011 11:38:58 AM

Shop Packet Print

Page 3

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Work Order ID: 73361

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 8/31/2011

Required Date: 9/12/2011

Start Qty: 1.00

Required Qty: 1.00

D4017-7

Manufactured No

100 Each

6.0000

1

1



Rib



Pl 11.09.19

Location

Loc Qty

Loc Code

WA

2

69730

1

72556

1

WA005

4

72008

1

72964

3

①

D4017-9

Manufactured No

100 Each

8.0000

2

2



Rib



Pl 11.09.19

Location

Loc Qty

Loc Code

WA

8

70341

2

72554

6

②

D4020-11

Manufactured No

100 Each

2.0000

2

2



End Mesh, Basket



Pl 11.09.19

Location

Loc Qty

Loc Code

WA

2

69648

2

372436 → ②

D4021-1

Manufactured No

100 Each

15.0000

3

3



Handle Plate



Pl 11.09.19

Location

Loc Qty

Loc Code

WA

15

69518

6

69777

9

③

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 5

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Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 8/31/2011

Required Date: 9/12/2011

Start Qty: 1.00

Required Qty: 1.00

D4034-041 Manufactured No

100 Each

1.0000

1

1



Aft Upper Rib Assembly

Location

Loc Qty

Loc Code

WA006

1

69157

1

100 Each

1.0000

1

1

D4034-043

Manufactured No



Fwd Upper Rib Assembly

Location

Loc Qty

Loc Code

WA006

1

70241

1

100 sf

747.4220

33

33

M304EX0.75-16F

Purchased No



Expanded Metal Flat SS

Location

Loc Qty

Loc Code

WA

747.421955

115012

95

117197

102.9036

117455

16.0341

117896

53.3264

118153

88.3763

118248

33.0983

118450

87.583255

118597

271.1

AN3-10A

Purchased No



Bolt

150 Each

102.0000

6

6

Location

Loc Qty

Loc Code

ST351

102

117795

102

33.

6

u109122

x6

Wednesday, August 31, 2011 11:38:58 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 8/31/2011

Required Date: 9/12/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD8 NAS1149DN832J Purchased No

150

Each

0.0000

2

2



N117881



(x2) HL 11/09/22

Washer

D2931 Manufactured No

150

Each

594.0000

2

2



Bumper

Location

Loc Qty

Loc Code

ST504

594

46064

594

D4021-5 Manufactured No

150

Each

0.0000

2

2



73478

Blanking Plate

MS20600-AD4W3 Purchased No

150

Each

1,497.000

2

2



11/9/22

Cherry Rivets

Location

Loc Qty

Loc Code

GA

958

118626

958

ST321

406

111636

48

117505

323

117601

35

WA018

133

107939

133

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Wednesday, August 31, 2011 11:38:59 AM

Work Order ID: 73361



Parent Item: D3913-041



Parent Item Name: Long Basket Base Assembly, 350

Start Date: 8/31/2011

Required Date: 9/12/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

150

Each

1,777.000

6

6



Nut

Location

Loc Qty

Loc Code

ST300

1777

117441

160

117601

400

117885

217

118451

1000

NAS1149F0332P

Purchased

No

150

Each

174.0000

12

12



WASHER

Location

Loc Qty

Loc Code

ST275

174

117735

75

118354

96

17317

3

msc 1-09-27

11/9/22

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

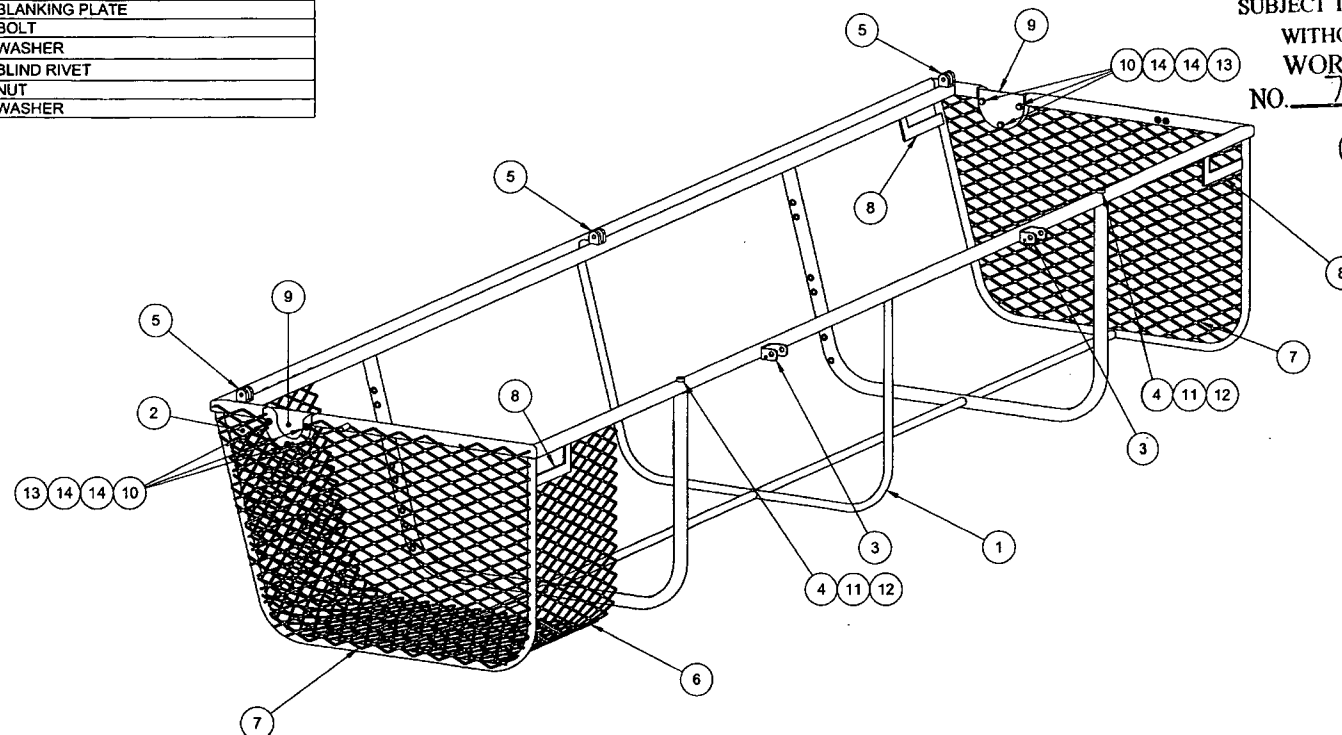
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

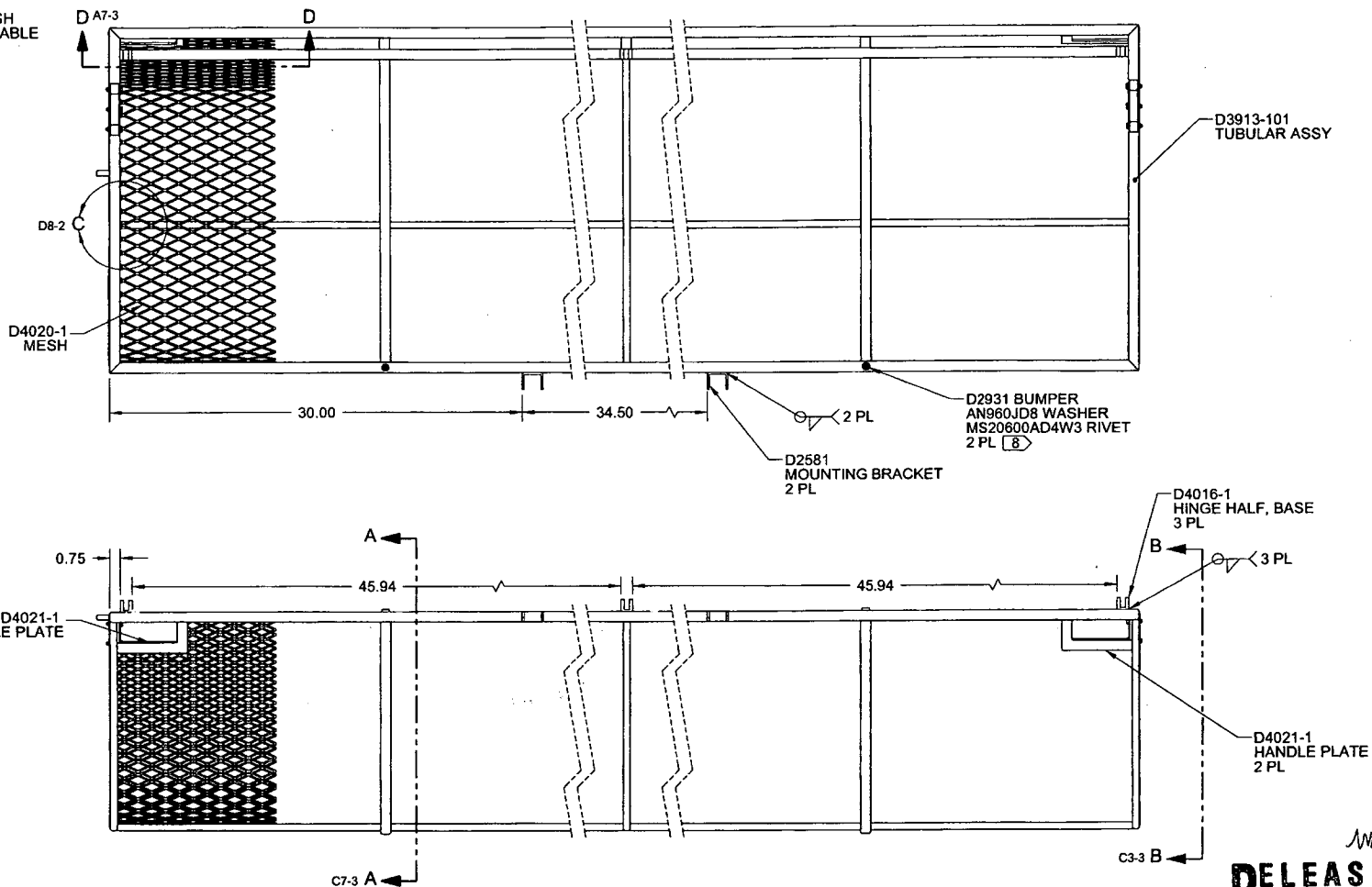
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 73361

RELEASED
2010-03-22
JPH

A NEW ISSUE		JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JFH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.16		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. D3913		REV. A	SHEET 1 OF 6
TITLE LONG BASKET BASE ASSY (350)		SCALE	NTS
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TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

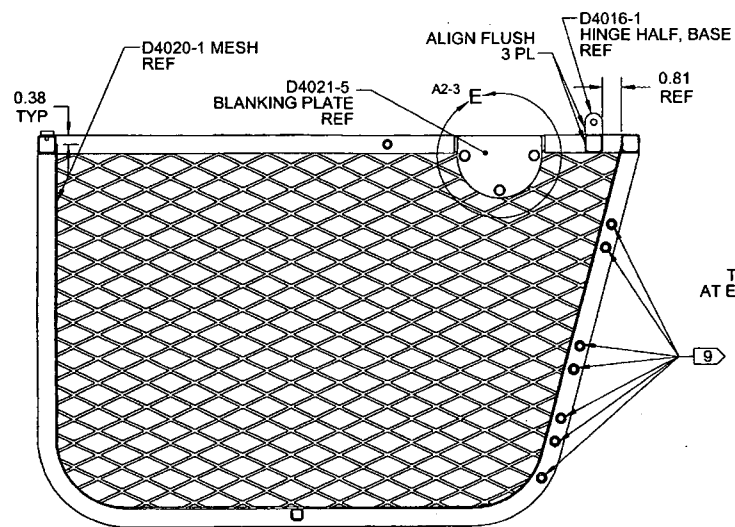
DETAIL C D7-2



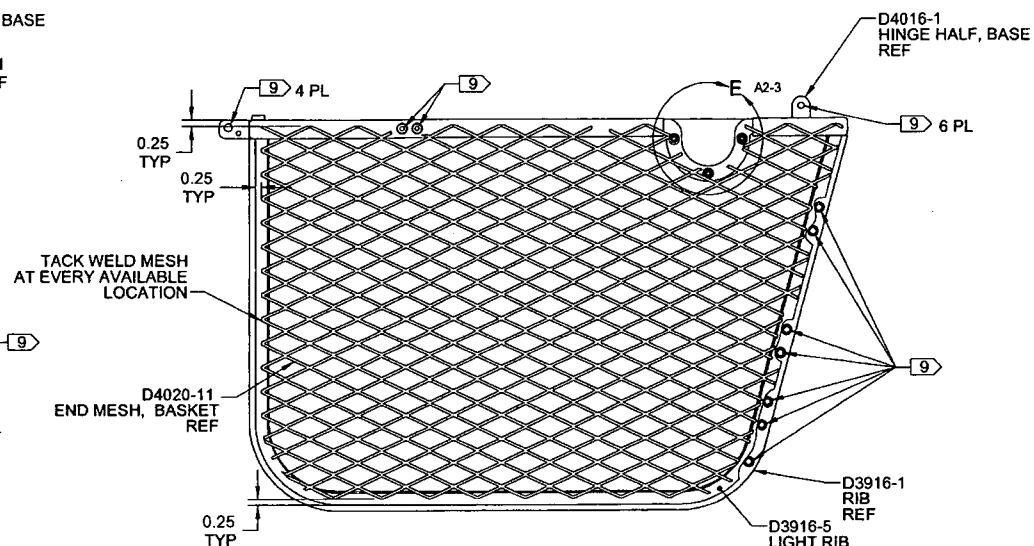
D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2010-03-27

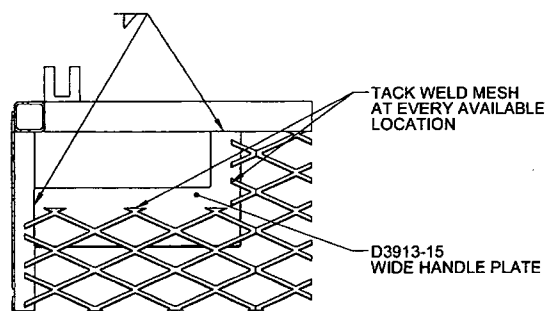
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



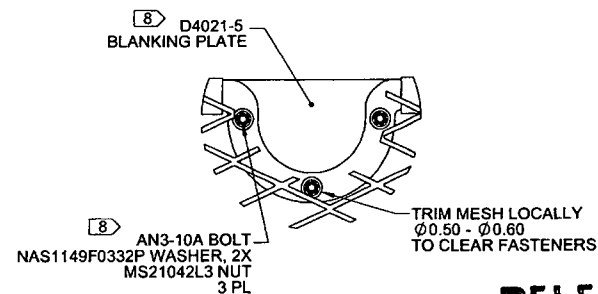
SECTION A-A A5-2



VIEW B-B A2-2



SECTION D-D D7-2
TYPICAL FOR ALL
HANDLE PLATES

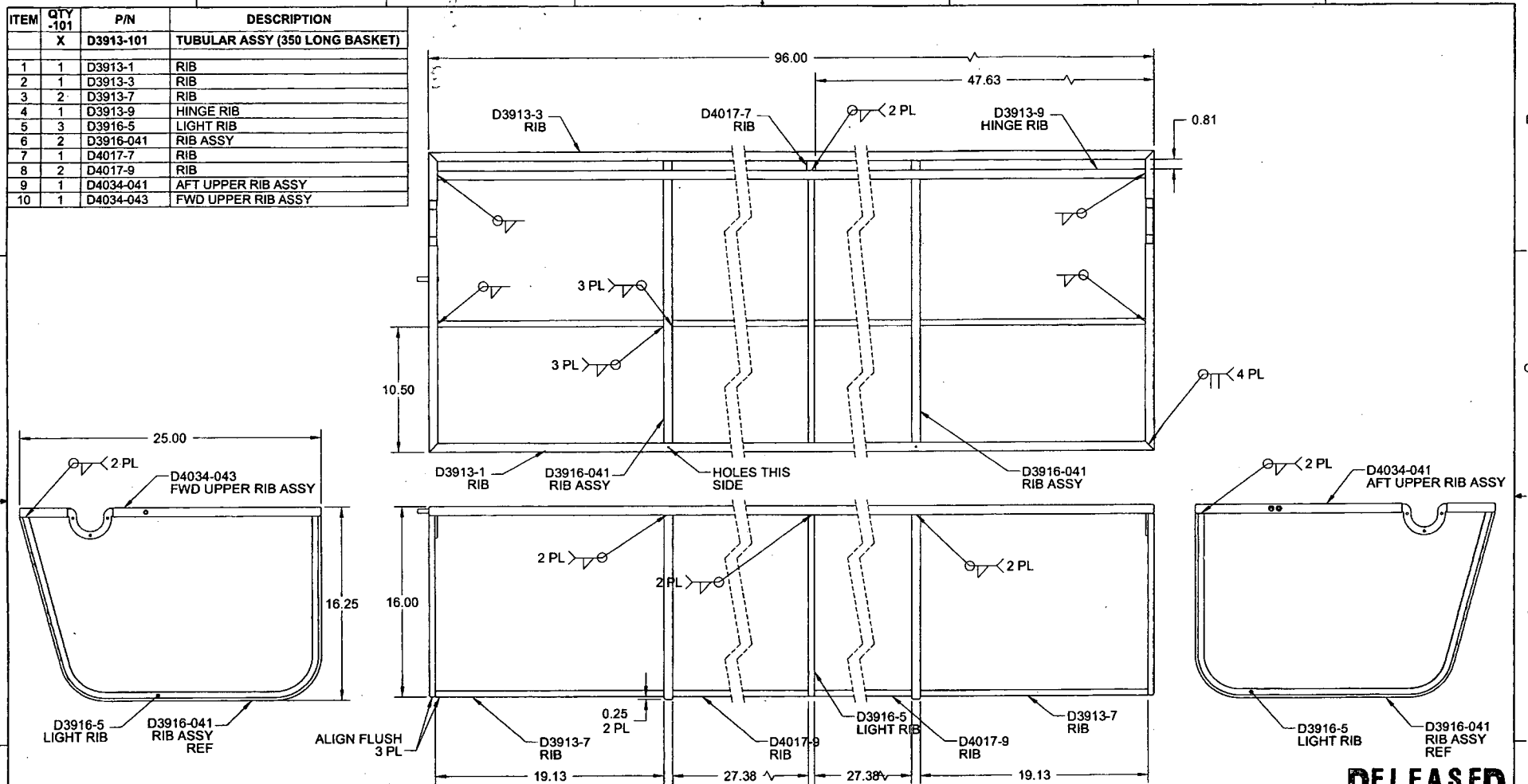


DETAIL E D2-3
D6-3

RELEASED
2010-03-22

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350) NTS	
DATE	10.03.16	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



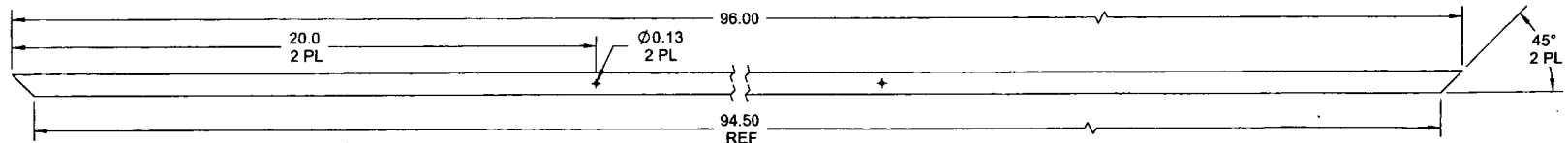
8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

NOTES:

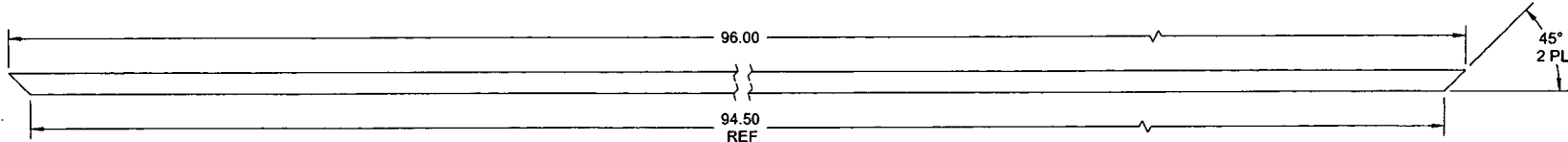
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D3913-101
- 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JRH		
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MFG. APPR.		TITLE LONG BASKET BASE ASSY (350)	SCALE NTS
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DE APPR.			
DATE	10.03.16		

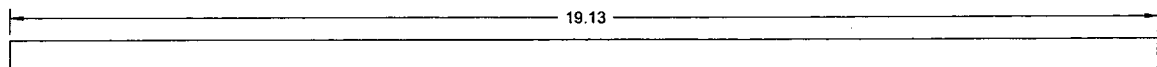
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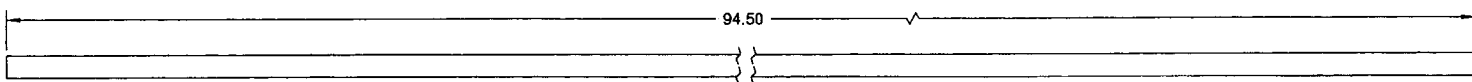
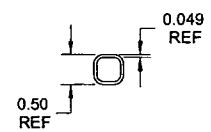
D3913-1 RIB



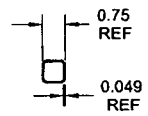
D3913-3 RIB



D3913-7 RIB



D3913-9 HINGE RIB

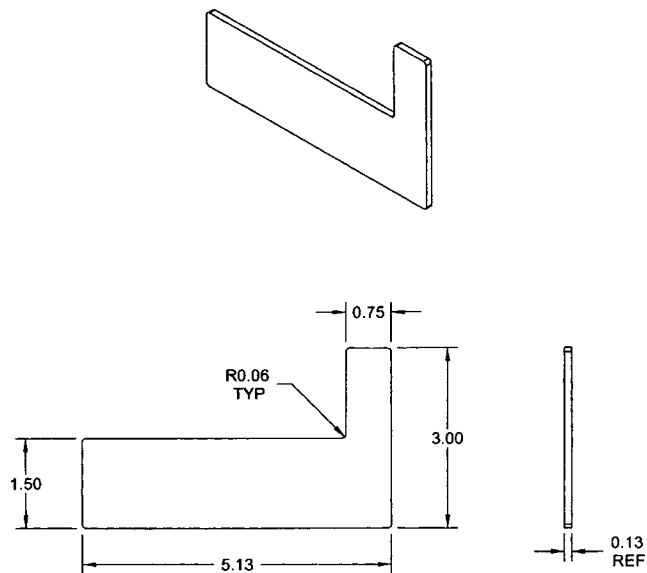


NOTES:

- 1) MATERIAL -1, -3, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

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DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

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MFG. APPR.		TITLE	SCALE
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